

Work Order ID 74544 -1

Tuesday, October 04, 2011 9:49:59 AM



Page 1

Item ID: K642-511

Revision ID:

Item Name: saddle kit 642-511

Start Date: 9/30/2011 Start Qty: 3.00

Required Date: 10/14/2011 Req'd Qty: 3.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: M.L.J.

Date: 11/10/04 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9467

Rev A

IIN D206-642

Rev N

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Create White labels per PPP K642-511

CHG004

5 12/1/24

dy br M.L.J. 12-1-3

110



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

11/12/25 12/1/2 30

Work Order ID 74544

Tuesday, October 04, 2011 9:49:59 AM



Page 2

Item ID: K642-511

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-511

Start Date: 9/30/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

S.2/2/24



Memo

0.00

130



Packaging

Packaging

Packaging

0.00

0.00

Memo

Identify and pack for shipping as per PPP K642-511 Location:

PK

ReoB

12/1/24

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

12/1/24

12/20/24

Picklist Print

Tuesday, October 04, 2011 9:50:04 AM

Page 1

10

Work Order ID: 74544

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00

Comments:

IPP Rev.A 07.06.05 new issue EC
IPP Rev.B 08.02.05 Per ECN1080P LI

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C35A



BOLT

Purchased

No

110

Each

73.0000

3



Location

Loc Qty

Loc Code

FG

4

18914

4

ST353

69

118628

19

119125

50

Purchased

No

110

Each

92.0000

9



27

M119530

Location

Loc Qty

Loc Code

FG

14

101261

4

116590

10

ST353

78

118757

36

119083

12

119125

30

Purchased

No

110

Each

84.0000

8



24

M119035

M112830

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

80

119035

80

AN3C36A



BOLT

AN3C41A



BOLT

Picklist Print

Tuesday, October 04, 2011 9:50:04 AM

Work Order ID: 74544

Parent Item: K642-511

Parent Item Name: saddle kit 642-511



Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00

AN4C6A



Bolt

Purchased

No

110

Each

242.0000

12

36

LocationLoc QtyLoc Code

FG

4

103344

4

ST356

238

116704

15

118451

123

118983

100

110

Each

152.0000

8

24



AN5C11A



Bolt

Purchased

No

LocationLoc QtyLoc Code

FG

4

104817

4

ST337

148

118706

48

118983

50

119127

50

110

Each

52.0000

4

12



AN5C12A



BOLT

Purchased

No

LocationLoc QtyLoc Code

FG

2

18918

2

ST338

50

118451

10

118983

40

12

Tuesday, October 04, 2011 9:50:04 AM

Shop Packet Print

Picklist Print

Tuesday, October 04, 2011 9:50:04 AM

Work Order ID: 74544

Parent Item: 642-511

Parent Item Name: saddle kit 642-511



Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00

AN5C13A



BOLT

Purchased

No

110

Each

103.0000

4

12

LocationLoc QtyLoc Code

ST338

103

28

75

117872

118983

110

Each

65.0000

1

3



AN5C15A



Bolt

Purchased

No

LocationLoc QtyLoc Code

ST338

15

15

118191

ST339

50

50

118267

110

Each

111.0000

2

6



AN5C32A



Purchased

No

LocationLoc QtyLoc Code

FG

4

18918

4

ST339

50

119035

50

ST340

57

116380

7

117407

25

117969

25

6

Tuesday, October 04, 2011 9:50:04 AM

Shop Packet Print

Picklist Print

Tuesday, October 04, 2011 9:50:04 AM

Page 4

Work Order ID: 74544

Parent Item: K642-511

Parent Item Name: saddle kit 642-511



Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00



Purchased

No

110

Each

51.0000

2

6



[Handwritten signature]

Location

Loc Qty

Loc Code

FG

2

18918

2

ST339

20

119083

20

ST340

29

117950

18

118985

11

[Handwritten signature]



Purchased

No

110

Each

47.0000

1

3



[Handwritten signature]

Location

Loc Qty

Loc Code

ST340

22

108407

22

ST341

25

118451

25

[Handwritten signature]



NAS1149C0332
R

Purchased

No

110

Each

0.0000

24

72



[Handwritten signature]

washer



Purchased

No

110

Each

0.0000

24

72



[Handwritten signature]

WASHER



NAS1149C0532
R

Purchased

No

110

Each

0.0000

8

24



[Handwritten signature]

WASHER

Tuesday, October 04, 2011 9:50:04 AM

Shop Packet Print

Page 4

Picklist Print

Tuesday, October 04, 2011 9:50:04 AM

Page 5

Work Order ID: 74544

Parent Item: K642-511

Parent Item Name: saddle kit 642-511



Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00

D206-648-013

CH67602



Manufactured No

110 Each

0.0000

GHW Modification

D2652



Manufactured No

110 Each

755.0000

Bushing



3
B758358
16 48
B73831

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

711

73755

100

73833

611

Manufactured No

110 Each

1,291.000

D2712



Set Screw



10 30
B76065

Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

1241

71160

1

72231

240

73837

1000

Manufactured No

110 Each

10.0000

D2932-1



Saddle LH Out, 206



1 3
12/12 A 3

Location

Loc Qty

Loc Code

ST428

10

72886

4

73466

6

Tuesday, October 04, 2011 9:50:05 AM

Shop Packet Print

Page 5

Picklist Print

Tuesday, October 04, 2011 9:50:05 AM

Work Order ID: 74544

Parent Item: K642-511

Parent Item Name: saddle kit 642-511



Start Date: 9/10/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00

S D2933-1
Saddle LH In, 206

Manufactured No

110 Each

3.0000



1 3

Location

Loc Qty

Loc Code

ST428

3

72884

3

S D2934
Saddle Spacer

Manufactured No

110 Each

6.0000



2 6

B74501

Location

Loc Qty

Loc Code

FG

6

31929

6

S D2935
Saddle Spacer

Manufactured No

110 Each

0.0000



2 6

B74503 12/1/11

S D2938-1
Saddle LH Out, 206

Manufactured No

110 Each

4.0000



1 3

sl x B75050 sl 12/1/11

Location

Loc Qty

Loc Code

ST428A

4

73468

4

S D2939-1
Saddle LH In, 206

Manufactured No

110 Each

4.0000



1 3

12/1/11

30

Location

Loc Qty

Loc Code

ST428A

4

73448

4

2

Picklist Print

Tuesday, October 04, 2011 9:50:05 AM

Page 7

Work Order ID: 74544

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00

D3396-3



Spacer

Manufactured No

110 Each

81.0000

2



SP

Location

Loc Qty

Loc Code

FG

10

26772

10

ST052

71

73349

71

6

D3407-043



Tow Ring

Manufactured No

110 Each

13.0000

1

3



B74519 SP

Location

Loc Qty

Loc Code

ST463

11

73341

11

ST464

2

68339

2

D3456-1



Washer

Manufactured No

110 Each

118.0000

1

3



12/1/2011 30

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

111

66848

3

71165

8

73493

100

3

Picklist Print

Tuesday, October 04, 2011 9:50:05 AM

Page 8

Work Order ID: 74544

Parent Item: K642-511

Parent Item Name: saddle kit 642-511



Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00

D3457-1



Washer

Manufactured No

110 Each

28.0000



2

6

Location

Loc Qty

Loc Code

FG	10
32409	10
ST054	18
67779	1
71849	17

Manufactured No

110 Each

886.0000



24

72

D3672-1



Phenolic Washer

Location

Loc Qty

Loc Code

ST074	884
64177	58
66821	466
72229	360
ST077	2
52505	2

Manufactured No

110 Each

867.0000



24

72

D3672-3



Phenolic Washer

Location

Loc Qty

Loc Code

ST074	867
64176	180
72230	187
73487	500

Tuesday, October 04, 2011 9:50:05 AM

Shop Packet Print

Page 8

Picklist Print

Tuesday, October 04, 2011 9:50:05 AM

Page 9

Work Order ID: 74544

Parent Item: K642-511

Parent Item Name: saddle kit 642-511



Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00

D3672-7

Manufactured No

110 Each

578.0000

24

72



Phenolic Washer

Location

Loc Qty

Loc Code

ST074

578

53237

244

64175

50

73488

284

Purchased No

110 Each

979.0000

20

60

MS21043-3



Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

907

118077

1

118614

492

118686

414

Purchased No

110 Each

845.0000

13

39

MS21043-4



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

805

117793

305

118686

500

Tuesday, October 04, 2011 9:50:05 AM

Shop Packet Print

Page 9

Picklist Print

Page 10

Tuesday, October 04, 2011 9:50:05 AM

Work Order ID: 74544

Parent Item: K642-511

Parent Item Name: saddle kit 642-511



Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 3.00

Required Qty: 3.00

MS21043-5

Purchased

No

110

Each

424.0000

4

12



Nut



11/12/27 J B

Location

Loc Qty

Loc Code

FG	20	
101418	20	
ST301	304	
112314	204	12
116548	100	
ST314	100	
118159	100	

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D206-642

Page 33 of 43

4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-511	SKIDTUBE INSTALLATION, LH
		X								D206-642-512	SKIDTUBE INSTALLATION, RH
			X							D206-642-515	SKIDTUBE INSTALLATION, LH
				X						D206-642-516	SKIDTUBE INSTALLATION, RH
1	1	1			X					D206-642-541	SKIDTUBE
						X				D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
							X			D206-642-549	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-551	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D3274-041	SKIDTUBE ASSEMBLY
1								1		D4362-041	SKIDTUBE ASSEMBLY
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		AN3C4A	* BOLT ⁽¹⁾
5A					2			2		NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
5B					2			2		D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3C41A	BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21043-3	NUT
12B	16	16	16	16						D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4	4	4						AN5C11A	* BOLT ⁽²⁾
14	4	4	4	4						(or AN5C12A)	
										AN5C11A	* BOLT ⁽²⁾
										(or AN5C13A)	
15A	8	8	8	8						NAS1149C0532R	WASHER (OR AN960C516L)
15B	8	8	8	8						D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12	12	12						AN4C6A	BOLT
17A	24	24	24	24						D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24	24	24						NAS1149C0432R	WASHER (OR AN960C416L)
18	12	12	12	12						MS21043-4	NUT
20A					9	9				D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A					1	1				D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A					1	1				D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B					1	1				D3536-15	* GASKET ⁽¹⁾
23A					1	1				D3535-23	* WEARSHOE ⁽¹⁾ (REPLACES D2656-23)
23B					1	1				D3536-23	* GASKET ⁽¹⁾
24A					1	1				D3535-39	* WEARSHOE ⁽¹⁾ (REPLACES D3287-1)
24B					1	1				D3536-39	* GASKET ⁽¹⁾
25A					1	1				D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B					1	1				D3536-35	* GASKET ⁽¹⁾
26A			8	8	78	78	8			AN3C4A	* BOLT ⁽¹⁾
26B			8	8	78	78	8			NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
26C			8	8	78		8			ALS7-1032-130	* INSERT ⁽¹⁾
											(or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34			1	1	1					AN4C5A	BOLT
35			1	1	1					NAS1149C0463R	WASHER (OR AN960C416)
36			1	1	1					D3413-1	RING
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER

• COPYRIGHT © 2000 BY DART AEROSPACE USA, INC. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: 0

Date: 11.06.15

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D206-642

Page 34 of 43

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
40									2	D3414-041	LUG ASSEMBLY (GHW)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)
50	9	9	3	3						AN3C36A	BOLT
51	3	3	3	3						AN3C35A	BOLT
52	24	24	12	12						NAS1149C0332R	WASHER (OR AN960C10L)
53	24	24	12	12						D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12	6	6						MS21043-3	NUT
55	2	2	2	2						D3396-3	SPACER
56A	1	1	1	1						AN5C35A	BOLT
56B	1	1	1	1						AN5C15A	BOLT
60	2	2	2	2						AN5C32A	BOLT
61	2	2	2	2						AN5C34A	BOLT
62	4	4	4	4						MS21043-5	NUT
80								1	1	D4368-041	FWD WEARPLATE ASSY
81								1	1	D4368-043	AFT WEARPLATE ASSY
82A								1	1	D4383-1	WEARPAD
82B								1	1	D4383-3	WEARPAD
83								20	20	D3873-3	BUSHING
84									24	D3411-3	WASHER
85								2		D3275-1	SPACER
86A								6	6	AN3C40A	BOLT
86B								2	2	AN3C37A	BOLT
86C								2	2	AN3C36A	BOLT
87								10	10	MS21043-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 OR D4362-041 ASSEMBLY ABOVE
 (2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

• COPYRIGHT © 2000 BY DART AEROSPACE USA, INC. •
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED
 OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC

Revision: 0
 Date: 11.06.15